

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of the claims in the application:

LISTING OF CLAIMS

1. (Currently Amended) A method of hydroforming hollow work-pieces by providing a pair of upper and lower tool inserts (~~B~~) having open axial ends and defining an elongated cavity (~~E~~) there between when said tool inserts are forced together in a Z-direction by means of a tool punch, said upper and/or lower tool inserts being composed of at least two segments that are in a locked position relative to a base plate in all directions (X, Y, Z) during the forming of the work-piece ~~and in contact with a base plate (A) on the side opposite to the cavity and~~
 - a) providing a hollow work-piece in said cavity;
 - b) sealing the ends of the hollow work-piece;
 - c) filling said work-piece with liquid;
 - d) applying an internal pressure to the inside of the work-piece by increasing the pressure on said liquid; and
 - e) moving said upper and lower tool inserts together to deform portions of the work-piece at any time after step a), wherein said inserts are in contact with said base plate on the side opposite to the elongated cavity and movement of said segments in the X- and the Y-direction is prevented by other means than by using vertical supports acting on ~~the~~ outer surfaces of the inserts.
2. (Currently Amended) Method according to claim 1, wherein the movement of the segments ~~are~~ is prevented by retaining elements extending from said base plate into cavities (~~D~~)

formed in said segments on the opposite side of the elongated cavity, said cavities being adapted to receive said retaining elements.

3. (Original) Method according to claim 1, wherein the movement of the segments ~~are~~ is prevented by retaining elements extending from said segments into cavities formed in said base plate on the opposite side of the elongated cavity, said cavities being adapted to receive said retaining elements.

4. (Currently Amended) Method according to claim 1, wherein the segments are guided onto the upper and the lower base blocks plates by guide columns (C).

5. (Currently Amended) Method according to claim 3, ~~wherein~~ wherein the retaining elements act as said guide columns.

6. (Original) Method according to claim 1, wherein the segments are kept in a fixed position mainly by friction forces acting between the base plate and the insert.

7. (Currently Amended) A tool for hydroforming a hollow work-piece comprising a pair of upper and lower tool inserts (B) having open axial ends and defining an elongated cavity (E) there between when said tool inserts are forced together by means of a tool punch in the Z-direction, said upper and/or lower tool inserts each being composed of segments that are in a locked position in ~~all~~ directions (X, Y, Z) and in contact with an upper and relation to a lower base plate (A) wherein said inserts are in contact with said upper and lower base plate, said tool is being free from vertical supports acting on ~~the~~ outer surfaces of the insert to prevent movement thereof in the X- and the Y-

direction.

8. (Currently Amended) A tool for hydroforming a hollow work-piece, comprising a pair of upper and lower tool inserts (B) having open axial ends and defining an elongated cavity (E) there between when said tool inserts are forced together by means of a tool punch in the Z-direction, said upper and/or lower tool inserts each being composed of segments that are in a locked position in all directions (X, Y, Z) and ~~in contact with an upper and~~ relation to a lower base plate (A), ~~wherein retaining~~ , wherein retaining elements preventing movement of the segments extend from said base plates into cavities (D) formed in said segments, said cavities being adapted to receive said retaining elements, said inserts are in contact with said upper and lower base plate.

9. (Original) A tool for hydroforming a hollow work-piece according to claim 7, wherein a plurality of retaining elements for preventing movement of the segments extend from said segments into cavities formed in said base plates, said cavities being adapted to receive said retaining elements.

10. (Currently Amended) A tool for hydroforming a hollow work-piece according to claim 7, wherein the segments are guided onto the upper and the lower base plates by guide columns (C) extending from said base plates.

11. (Currently Amended) A tool for hydroforming a hollow work-piece according to claim 7, wherein the upper and the lower base plates are guided onto the segments by guide columns (C) extending from said segments.

12. (Original) A tool for hydroforming a hollow work-piece according to claim 8, wherein the retaining elements also act as said guide columns.

13. (Original) A tool for hydroforming a hollow work-piece according to claim 8, wherein the retaining elements are in the shape of pins.